

Work Order ID 104836

July-22-13 7:20:24 AM

104836

Page 1

Item ID: D2893-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Support

Stop *NS2*

Start Date: 7/22/13

Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/02/13

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 13-07-22

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2893	C								
100		0.00							
100	HAAS CNC VERTICAL MACHINING #1								
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA081 2-Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

13-07-24
13-07-25
02
02
13-07-27
13-07-24
13-07-25
02
02
13-07-27
13-07-29

20 0
20 0
20 0
20 0

July-22-13 7:20:24 AM

Page 2

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

Work Order ID 104836

July-22-13 7:20:24 AM

104836

Page 3

Item ID: D2893-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Support

Stop *NS2*

Start Date: 7/22/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/02/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/7/31/13

MF

13-7-30

Picklist Print

July-22-13 7:20:28 AM

Page 1
T

Work Order ID: 104836

104836

Parent Item: D2893-1

D2893-1

Parent Item Name: Support

Start Date: 7/22/13

Required Date: 9/02/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C02.11.26Reformat: Added P/OKJ
 IPP D 06.04.19 removed alodine EC
 IPP Rev:E Added priming as per Rev B 07-04-30 JLM
 IPP F 08.03.19 Re-format EC verified by: DD
 IPP Rev:G 08-05-15 add QC14 DD verified by:EC
 11.08.04 as per dwg rev.C DD verf:EC
 IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	23.0000	0.5	10.52632			

DSK078

D2893-1 TURNING DETAIL

**

AT 13-07-22

Location

Loc Qty

Loc Code

MAT060

23

103147

4

103581

12

103894

7

x4

x6

DART AEROSPACE LTD		Work Order:	104836
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.998	2.996	3.000	2.997	2.999
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.129	.130	.134	.132	.129
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.140	.140	.139	.140	.140
AG	0.140	0.160		.145	.152	.147	.148	.147
AH	1.360	1.400		1.380	1.380	1.381	1.377	1.376
AI	0.040	0.060		.046	.052	.055	.048	.046
AJ	1.190	1.230		1.223	1.219	1.223	1.217	1.217
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.067	.063	.063	.063	.063
AM	0.240	0.260		.250	.240	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	13 07 25
Audited by:	13.7.29 <i>[Signature]</i>	Date:	13.7.29
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	104836
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6 #	7 #	8 #	9 #	10 #
HAAS Section								
AA	2.985	3.005		3.000	2.999	2.998	2.998	2.997
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.133	.133	.130	.130	.130
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.141	.141	.140	.142	.140
AG	0.140	0.160		.152	.147	.144	.153	.145
AH	1.360	1.400		1.380	1.379	1.380	1.377	1.379
AI	0.040	0.060		.052	.054	.049	.056	.050
AJ	1.190	1.230		1.217	1.223	1.220	1.218	1.225
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	ET	Date:	15 07-25
Audited by:	RP	Date:	13 7-29
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	104836
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11 #	12 #	13 #	14 #	15 #
HAAS Section								
AA	2.985	3.005		2.997	2.997	3.000	3.000	2.993
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.133	.133	.130	.139	0.150
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.142	.141	.140	.140	0.147
AG	0.140	0.160		.146	.148	.147	.147	0.153
AH	1.360	1.400		1.378	1.377	1.378	1.378	1.377
AI	0.040	0.060		.049	.050	.049	.050	0.055
AJ	1.190	1.230		1.218	1.222	1.219	1.220	1.222
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	RT ^{D1} 0105-0 JFC	Date:	13-07-25
Audited by:	DP	Date:	13-7-29
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

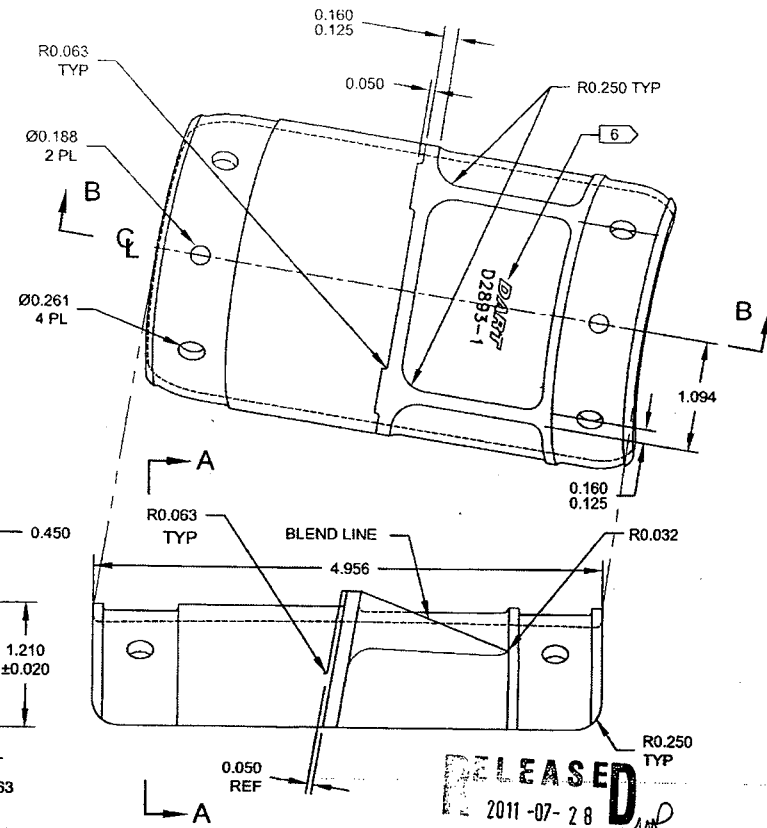
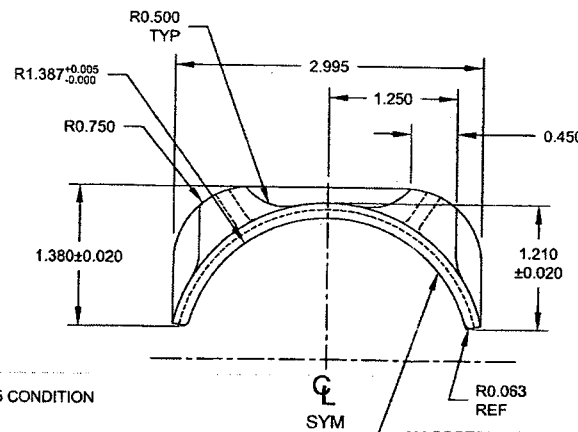
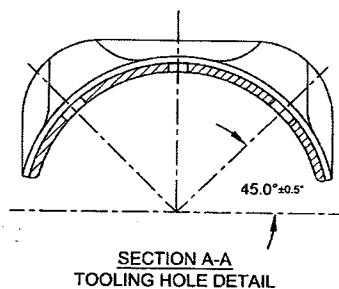
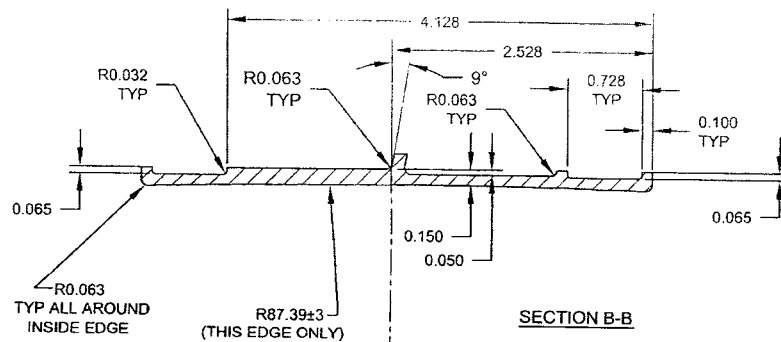
DART AEROSPACE LTD		Work Order:	104836
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16 $\frac{1}{8}$	17 $\frac{1}{16}$	18 $\frac{1}{32}$	19 $\frac{1}{64}$	20 $\frac{1}{128}$
HAAS Section								
AA	2.985	3.005		2.998	2.997	2.998	2.998	2.998
AB	0.440	0.460		0.450	0.450	0.450	0.450	0.450
AC	0.125	0.160		0.151	0.150	0.151	0.151	0.151
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AF	0.125	0.160		0.147	0.143	0.148	0.147	0.148
AG	0.140	0.160		0.150	0.150	0.152	0.151	0.152
AH	1.360	1.400		1.376	1.380	1.377	1.378	1.378
AI	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AJ	1.190	1.230		1.220	1.221	1.221	1.220	1.220
AK	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AL	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.533	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	JFC	Date:	2013-07-27
Audited by:	TRP	Date:	B. 7. 29
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	



NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03\"/>

D2893-1 SUPPORT

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN	Q		
DRAWN	Q		
CHECKED	AS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2893
REV. C
SHEET 1 OF 1
TITLE Ø2.750 SUPPORT
SCALE NTS

COPYRIGHT © 2001 BY DART AEROSPACE LTD
THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 104836-ML5
13-07-22